

*GREEN*

Date: Thursday, 4/26/2007 3:34:03 PM  
User: Kim Johnston

**Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 32080	
Estimate Number : 10178	
P.O. Number : <i>N/A</i>	Part Number : D25941
This Issue : 4/26/2007	Drawing Number : D2594 REV C
S.O. No. : <i>N/A</i>	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : C
First Issue : <i>N/A</i>	Material : <i>N/A</i>
Type : MACHINED PARTS	Due Date : 5/30/2007
Previous Run : 31109	Qty: 160 Um: Each
Written By : <i>[Signature]</i>	
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 02.08.22 Make in Cobra KJ	
est E 06.12.11 ecn 836 EC	

**Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0625 6061-T6 Round Bar .625"



Comment: Qty.: 0.0547 f(s)/Unit Total : 8.7528 f(s)

Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)

1100-0 (QQ-A-225/1) Ø0.625" Rod

(M5052H32R0.625) or (M6061T6R0.625)

Batch *M1104489* *ml 07/05/24* *162*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Make as per Dwg D2594-1 and Folio FA262.

2-Break all sharp edges 0.010 max.

*ml 07/05/24* *162*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07/05/24* *162*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*28 07/05/24* *162*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

*112* *07-05-28* *162*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: □ Date: 07/05/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



~~SM 104476~~



162X

Comment: POWDER COATING

— Powder Coat - OLIVE DRAB GREEN

(Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

BR/M-L

07/05/28.

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



162

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/05/28

8.0

PACKAGING 1

PACKAGING RESOURCE #1



162X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-16

M-L

07/05/28

9.0

QC21

FINAL INSPECTION/W/O RELEASE



162

Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion



✓ 07/05/29

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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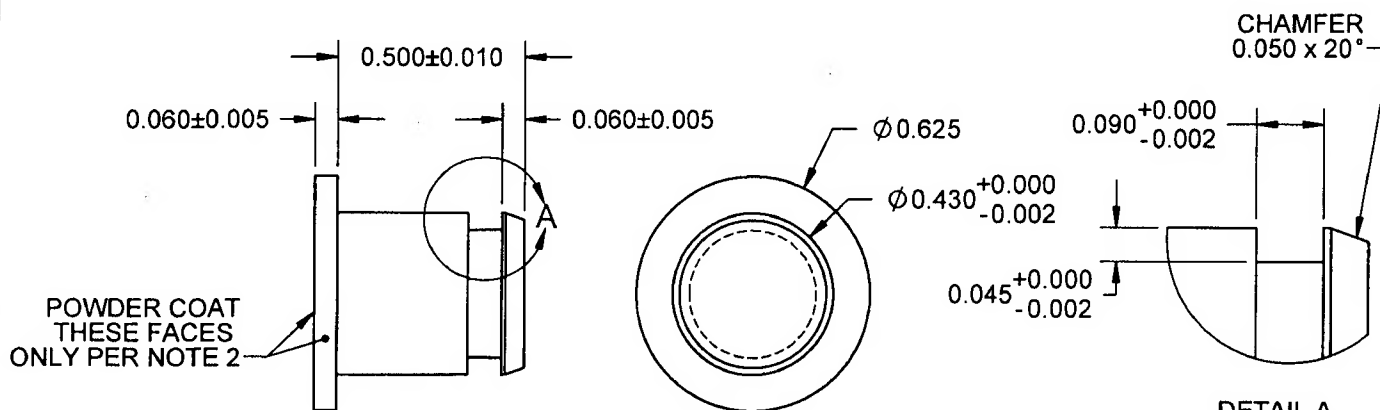
NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. <b>D2594</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.20</b>		TITLE <b>PLUG</b>	SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

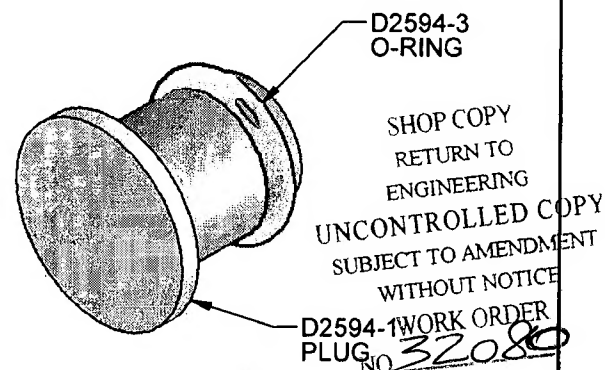
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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